

Statement of Work for

NCSX Modular Coil Winding Form  
Manufacturing Development and Prototype Fabrication

NCSX-SOW-141-01-01

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**Controlled Document**

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**REVISIONS**

Revision No.	Description of Change	Date
Rev. 0	All	10/15/02
Rev. 1	Added Section 4.2 on earned value reporting	10/18/02

## TABLE OF CONTENTS

	Page
1. GENERAL INFORMATION	
1.1 Introduction	1
1.2 Background	1
1.3 Scope	5
1.4 Applicable Documents	5
2. WORK REQUIREMENTS	
2.1 Technical Requirements	6
2.2 Subcontractor's Recommendations	7
2.3 Additional Manufacturing Development Activities	8
2.4 Processing Plans	8
2.5 Budgetary Cost Estimate	8
2.6 Processing Plans for Prototype	8
2.7 Prototype Manufacture	8
2.8 Final MIT Plan for Production Winding Forms	8
2.9 Firm Fixed Cost and Schedule Proposal	8
3. QUALITY ASSURANCE	
3.1 Inspection / Surveillance / Audit by PPPL	9
3.2 Subcontractor's Responsibility for Conformance	9
3.3 Subcontractor's Quality Assurance Program	9
3.4 Processing Plans	10
3.5 Inspection and Test Procedures	10
3.6 Document Traceability and Records	10
3.7 Equipment / Material Identification and Status	10
3.8 Calibration of Test and Measuring Equipment	10
3.9 Control of Special Processes	11
3.10 Release for Shipment Form	11
3.11 Process History	11
3.12 PPPL Receiving and Inspection	11

## **TABLE OF CONTENTS (CONT'D.)**

4. DELIVERABLES	
4.1. Weekly Reports	12
4.2 Earned Value Reporting	12
4.3 Technical Reports	12
4.4 Prototype Processing Plans	12
4.5 Preliminary Production Processing Plans	12
4.6 Prototype Winding Form	12
4.7 Production Processing Plans	12
4.8 Documentation	12
4.8 Tooling	13

# 1. GENERAL INFORMATION

## 1.1 Introduction

Stellarators are a class of magnetic fusion confinement devices characterized by three dimensional magnetic fields and plasma shapes and are the best-developed class of magnetic fusion devices after the tokamak. The stellarator concept has greatly advanced since its invention by Dr. Lyman Spitzer, the founding director of the Princeton Plasma Physics Laboratory (PPPL), during the 1950's. A traditional stellarator uses only external magnetic fields to shape and confine the plasma. The National Compact Stellarator Experiment (NCSX) is the first of a new class of stellarators known as "compact stellarators." The differentiating feature of a compact stellarator is the use of plasma current in combination with external fields to accomplish shaping and confinement. This combination permits a more compact device. The NCSX project is managed by PPPL in partnership with the Oak Ridge National Laboratory. This Subcontract will be administered by PPPL. Operation of NCSX is scheduled to begin in July 2007.

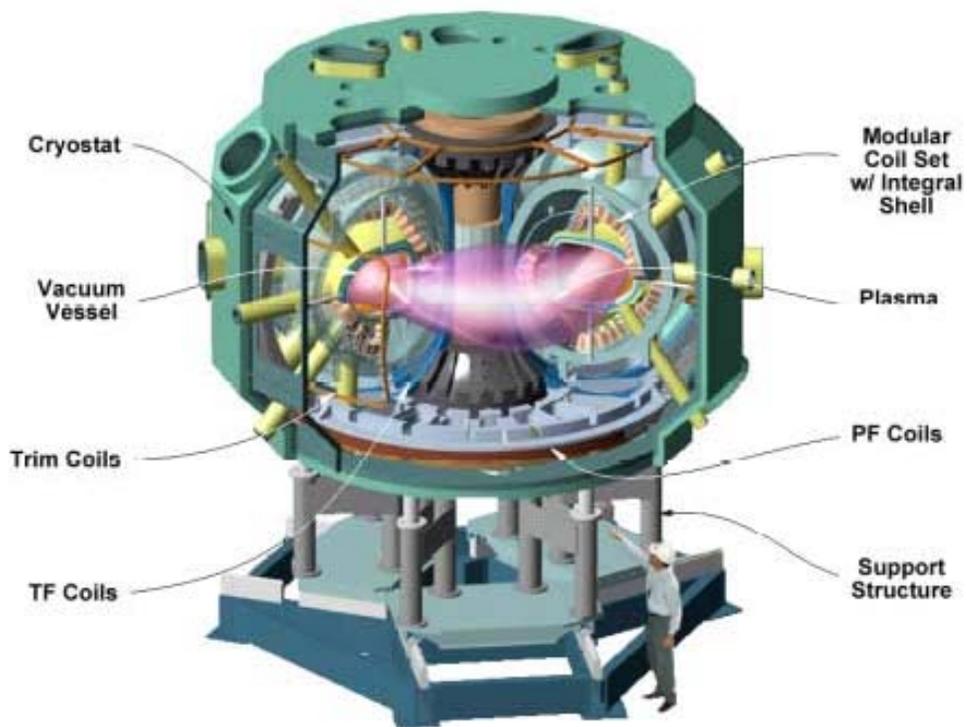
In preparation for fabrication of critical components, PPPL is initiating manufacturing development activities. This Statement of Work is for one of these activities - the coil winding forms, which are described below.

## 1.2 Background

Figure 1 is a sectional view of the NCSX device showing its major components. Note the modular coil set with an integral shell; the stainless steel winding forms that comprise this shell are the subjects of this SOW.

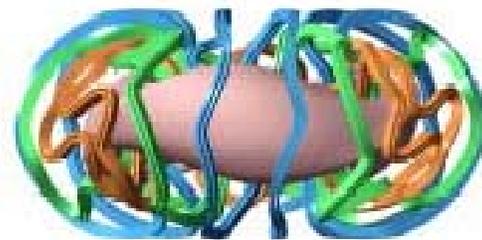
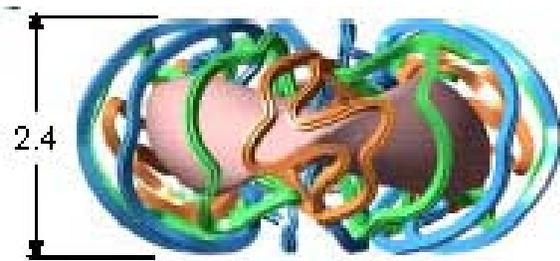
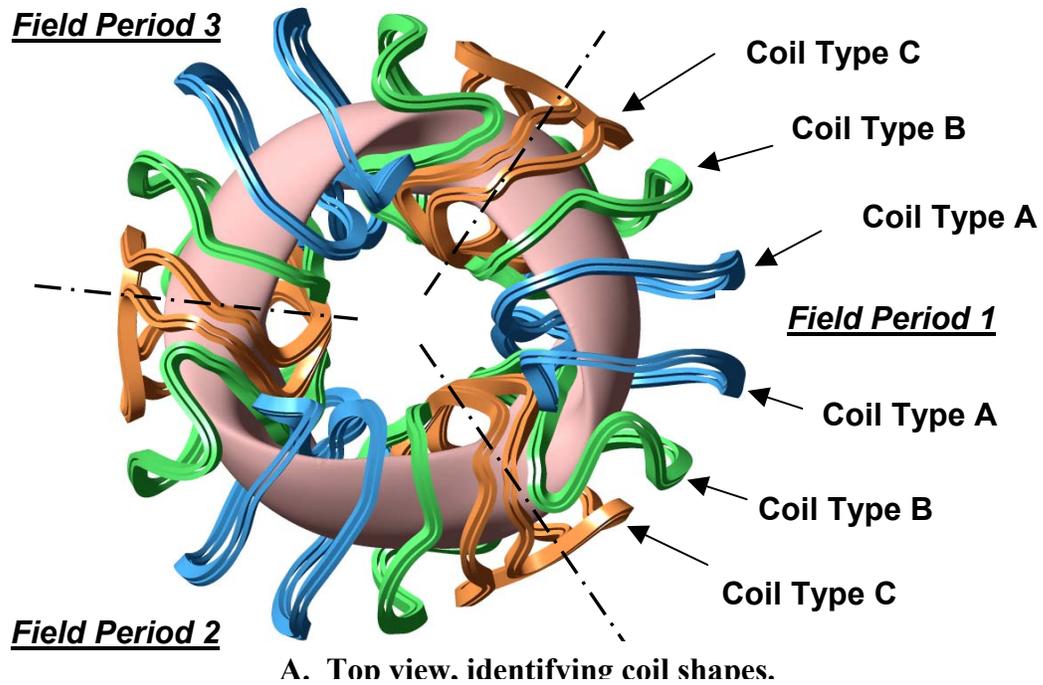
The modular coil windings are shown in Figure 2 without their associated winding forms to permit the complex shape of the windings to be more readily seen. There are three distinct shapes; six of each make up the complete modular coil set. To fabricate these windings to the precise shapes required, stranded copper cable conductor is wound on the machined stainless steel winding forms, as shown in Fig. 3. In addition to defining the shape of the coils, the winding forms also provide the strong structural support necessary to react electromagnetic loads as high as 7000 lbs. / in. Figure 4 shows the final assembly of the NCSX modular coil set.

*Note: Figures 1-4 are only for illustration and should not be used in the performance of this Scope of Work.*



**Fig. 1. The NCSX Device and Definition of its Major Components**

*Note in particular the Modular Coil Set with Integral Shell. This integral shell is comprised of the (18) winding forms that are the subject of this SOW. A typical winding form is shown in Fig. 3.*



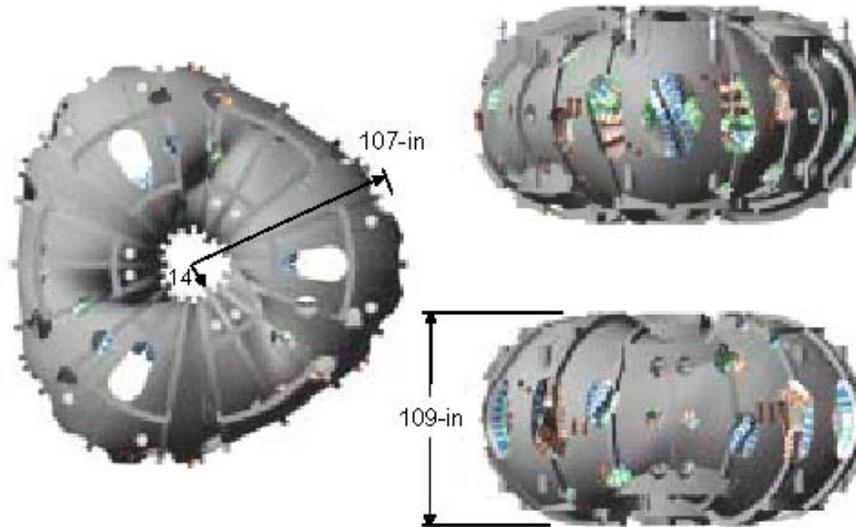
B. Side View at split line between periods.

C. Side view looking into Type A coils.

**Fig. 2. The NCSX Modular Coil Windings**

*The windings are shown without their associated winding forms so their complex shapes can be easily seen. In order to manufacture these windings to their precise shapes, stranded copper conductor is wound on the machined winding forms (shown in Fig.3), which are the subject of this Statement of Work. Six of each of the three winding form shapes are required. ( Dimensions in meters)*





**Fig. 4. Final Assembly of the NCSX Modular Coil Set**

*Shown above is the final assembly of the eighteen modular coils (six each of three coil shapes).*

### **1.3 Scope**

The scope of this SOW includes manufacturing development for all three winding form shapes, the production of a full-scale prototype of one winding form, and, based on these activities, a firm fixed price and schedule proposal for the eighteen production castings. The SOW tasks focus on the difficult aspects of manufacturing these shapes: tolerance control; maintenance of low magnetic permeability; machining of the complex geometry; control of distortion during heat treatment; and timely, low-cost fabrication. The production of the full-scale prototype is meant to give the Subcontractor the experience needed to develop and submit a firm fixed price and schedule proposal as a final deliverable of this effort.

### **1.4 Applicable Documents**

Product Specification for the Prototype Modular Coil Winding Form (NCSX-CSPEC-141-01-00) is the complete specification for the prototype modular coil winding form. The initial release of this specification (Rev. 0), to be used only for planning and proposal preparation, is available on the PPPL Procurement Web. A revised version will be provided prior to the performance of this Statement of Work. The specification identifies applicable Pro/Engineer drawings and models that define the geometry of the prototype modular coil winding form. Preliminary drawings and

models of the prototype winding form, to be used only for planning and proposal preparation, are currently available on the PPPL FTP server. Currently, the exact shapes of the coil windings are being optimized. The changes are expected to be minor with respect to manufacturing issues; bend radii and tolerances will not be changed. The only change expected in the specification will be to revise the file names of the drawings and models for the optimized shapes. Drawings and models that are released for prototype fabrication will be provided prior to the performance of this Statement of Work.

#### Product Specification for the Modular Coil Winding Forms (NCSX-CSPEC-141-02-00)

This document will be the complete specification for the modular coil winding forms. A released version of this specification, which will be similar in content to the specification for the prototype modular coil winding form (NCSX-CSPEC-141-01-00), will be provided prior to the performance of this Statement of Work. A revised version will be provided prior to the Subcontractor providing a firm fixed price bid and schedule proposal. The specification identifies applicable Pro/Engineer drawings and models that define the geometry of the modular coil winding forms. Preliminary drawings and models of the modular coil winding forms, to be used only for planning and proposal preparation, are currently available on the PPPL FTP server. Drawings and models that are released for fabrication will be provided prior the Subcontractor providing a firm fixed price bid and schedule proposal.

**2. WORK REQUIREMENTS:** The tasks described below should be performed approximately in the order indicated. It is expected that the Subcontractor may be working on several in parallel. Schedule requirements are described in the Subcontract.

#### **2.1 Technical**

**2.1.1 Describe the manufacturing methods for the three winding form shapes:** The Subcontractor shall describe the manufacturing methods for fabricating, inspecting, and machining the modular coil winding forms and proposed Quality Assurance provisions. (Ref.: Specification # NCSX-CSPEC-141-01-00, Sects. 3 and 4).

**2.1.2 Alloy Selection:** Describe in detail the composition and mechanical and physical properties (at 77 K and at room temperature) of the chosen alloy and your experience with using this alloy. (Ref.: Specification # NCSX-CSPEC-141-01-00, Sect. 3.2.1)

**2.1.3 Copper Cladding Development Samples:** Subcontractor is to produce development samples for the copper cladding process (Ref.: Specification # NCSX-CSPEC-141-01-00, Sect. 3.2.1.2). The developmental samples shall consist of cladding applied to 1” thick type 316 stainless steel plates 6” x12”.

**2.1.4 Mold Fabrication:** Describe details of the proposed mold design and fabrication (including modeling).

**2.1.5 Flow Solidification / Distortion Analyses:** Describe analyses, plans, and schedules.

**2.1.6 Casting details:** Describe the details of the proposed casting process.

**2.1.7 Post-Casting Processing**

**2.1.7.1 Non-Destructive Testing:** Describe the non-destructive testing methods proposed for evaluating the castings for defects. (Ref.: Specification # NCSX-CSPEC-141-01-00, Sects. 4.2.8-4.2.10).

**2.1.7.2 Dimensional inspection and verification:** Describe measuring instrumentation, proposed details of measurements and how these measurements will be used to verify that the cast part meets the requirements. (Ref. Specification # NCSX-CSPEC-141-01-00, Sects. 4.2.7)

**2.1.7.3 Winding Form Repairs:** Describe expected defects, proposed repair methods, and impact on winding form material properties. If Hot Isostatic Pressing (HIPing) or another post processing method is proposed, provide detailed rationale for method selection. (Ref. Specification # NCSX-CSPEC-141-01-00, Sect. 3.3.2.2).

**2.1.7.4 Heat Treatment:** Describe heat treatment(s) and fixtures required for chosen alloy. Describe methods for controlling distortion during heat treatment. (Ref.: Specification # NCSX-CSPEC-141-01-00, Sect. 3.3.2.1).

**2.1.7.5 Machining and Final Finishing:** Describe details of proposed machining methods and any final finishing operations (including any mechanical surface finishing methods and final cleaning methods). (Ref. Specification # NCSX-CSPEC-141-01-00, Sect. 3.2.1.5)

**2.1.7.6 Final Inspection:** Describe the final inspection methods proposed to assure that the winding forms meet all of the requirements of NCSX-CSPEC-141-01-00.

**2.2 Subcontractor’s Recommendations:** The Subcontractor shall recommend changes to the design or Specification that could make the winding forms easier to manufacture, reduce

costs, improve the fabrication schedule, or reduce risk. PPPL reserves the right to accept or reject any or all of the Subcontractor's change recommendations, or to incorporate them into the specification in whole or in part, even in the event that the contract award for production winding forms is to another supplier.

**2.3 Additional Manufacturing Development Activities:** The Subcontractor shall perform and document any additional agreed upon manufacturing development activities that are necessary to develop the knowledge required to produce the three winding form shapes and reduce the technical, cost, and schedule risk. (These additional activities are to be defined in the Subcontractor's Proposal and shall be set forth in a revised Statement of Work.)

**2.4 Preliminary Manufacturing / Inspection / Test (MIT) and Quality Assurance (QA) Plans for Production Coils:** The Subcontractor shall produce preliminary MIT and QA Plans for all three winding shapes. (See 3.4 of this SOW for plan descriptions)

**2.5 Budgetary Cost and Schedule Estimate:** The Subcontractor shall prepare a Budgetary Cost and Schedule Estimate for all (18) production winding forms and required tooling in the format provided in the subcontract based on the MIT plan developed in 2.4.

**2.6 Processing Plans for Prototype:** The Subcontractor shall develop MIT and QA Plans (see 3.4) for the Prototype Winding Form.

**2.7 Prototype Manufacture:** The Subcontractor shall manufacture a full-scale prototype winding form, including any required tooling.

**2.8 Final MIT and QA Plans for Production Winding Forms:** The Subcontractor shall develop final MIT and QA Plans (see 3.4) for production of all three winding form shapes based on these supplied documents. 30 days before Final MIT and QA Plans for Production Winding Forms are due, PPPL will provide an approved specification (NCSX-CPEC-141-02-00) and associated Pro/Engineer models and drawings that are released for fabrication. These are expected to be similar to those used in the performance of this SOW, but with updates based on the manufacturing development activities and the production of the Prototype performed under this SOW.

**2.9 Firm Fixed Price and Schedule Proposal:** The Subcontractor shall provide a firm fixed price and schedule proposal for the (18) production winding forms in the format provided in the

Subcontract based on Sect. 2.8. 30 days before the Firm Fixed Price and Schedule Proposal for Production Winding Forms are due, PPPL will provide an approved specification (NCSX-CPEC-141-02-00) and associated Pro/Engineer models and drawings that are released for fabrication. These are expected to be similar to those used in the performance of this SOW, but with updates based on the manufacturing development activities and the production of the Prototype performed under this SOW.

### **3. QUALITY ASSURANCE**

**3.1 Inspection/ Surveillance/Audit by PPPL:** Authorized representatives of PPPL and the U. S. Government shall have the right at all reasonable times to visit the Subcontractor's premises and those of Subcontractor's suppliers during the performance of the Subcontract for the purposes of inspection, surveillance, audit and/or obtaining any required information as may be necessary to assure that items or services are being furnished in accordance with specified requirements. Such visits shall be coordinated with the Subcontractor's personnel to minimize interference with the normal operations of said premises. The Subcontractor shall make available records and documentation necessary for this function and shall provide all reasonable facilities and assistance for the safety and convenience of PPPL and/or U. S. Government representatives in the performance of their duties. PPPL and the U. S. Government recognize the Subcontractor's right to withhold information concerning proprietary processes. The Subcontractor agrees to insert the paragraph above in each lower-tier procurement issued hereunder.

**3.2 Subcontractor's Responsibility for Conformance:** Neither PPPL review and/or approval of Subcontractor's documents nor PPPL inspection of Subcontractor's items or services shall relieve the Subcontractor of responsibility for full compliance with requirements of the purchase order/contract. The Subcontractor is responsible for assuring that all requirements and restrictions are imposed on any sub-tier suppliers.

**3.3 Subcontractor's Quality Assurance Program:** The Subcontractor shall establish and maintain an effective Quality Assurance Program to assure that the Subcontractor's work meets the required quality and is performed in accordance with contractual requirements. Subcontractor's quality assurance function shall be organized to have sufficient authority and

independence to identify quality problems, verify conformance of supplied items or services to specified requirements and obtain satisfactory resolution of conflicts involving quality.

**3.4 Processing Plans:** The Subcontractor shall prepare Manufacturing/Inspection Test (MIT) and Quality Assurance (QA) Plans for PPPL review and approval.

3.4.1 Within the MIT plan, the Subcontractor shall identify processes and materials and show their integrated flow into end items. The plan shall also identify critical manufacturing operations and inspections and tests. Procedures and/or protocols for contaminant control and cleanliness shall be included with the MIT. Preparing the Plan may include developing a flow chart and generating Process Sheets/Shop Travelers, etc. PPPL may designate selected manufacturing, inspection and/or test operations as mandatory “witness” points based on the MIT plan. Subcontractor shall provide PPPL with a minimum of five (5) working days notice in advance of witness points described in the MIT plan. Such witness points shall be mutually planned to minimize delays.

3.4.2 The Quality Assurance Plan shall describe the specific quality assurance and quality control procedures and practices to meet the requirements of this subcontract and associated specification.

**3.5 Inspection and Test Procedures:** Inspections and tests shall be performed in accordance with written procedures referencing criteria for acceptance or rejection. Actual data and accept/reject status for each inspection and test shall be documented for each winding form.

**3.6 Document Traceability and Records:** The Subcontractor shall maintain a system of documentation whereby objective evidence of required operations, inspections, examinations, and tests is systematically compiled, indexed and stored. Such objective evidence may include "travelers"; and material test, certification, inspection, examination, test and discrepancy reports; which shall be complete, legible, and validated by responsible personnel and shall be traceable to subject items.

**3.7 Equipment/Material Identification and Status:** Material and equipment identification shall be maintained throughout the program and be traceable to the records. Status of acceptability shall be readily discernible through the Subcontractor's use of tags, stamps, serial numbers or other positive means.

**3.8 Calibration of Test and Measuring Equipment:** Inspections and tests shall be performed using properly calibrated measuring and test equipment. Subcontractor shall have in its possession the necessary equipment to perform the required inspections and tests. Calibration

standards shall be traceable to the National Institute for Standards and Technology (NIST) or equivalent acceptable to PPPL and shall not be used for shop inspections, but instead be protected against damage or degradation.

**3.9 Control of Special Processes:** Subcontractor shall use trained and qualified personnel and qualified written procedures in accordance with specified requirements for the performance of certain special processes, including but not limited to, soldering, electronic assembly, brazing, welding, plating, heat treatment, nondestructive examination, etc. Copies of special process procedures shall be available for review by Princeton and submitted to Princeton for review and approval if requested.

**3.10 Release for Shipment Form:** Subcontractor shall have a signed "Product Quality Certification and Shipping Release" Form ( Attachment 1 of this SOW) prior to NCSX Project acceptance of procured items or services for full or partial shipment. NCSX Project reserves the right to refuse to accept shipments unless accompanied by a signed "Shipping Release Form".

**3.11 Process History:** Subcontractor shall provide to PPPL, with the shipment release request, a Process History, which includes a compilation of documents, detailing the objective evidence of the acceptability of the work performed. The Process History shall include as a minimum, but not be limited to, the following:

**3.11.1 Material Certifications:** The Subcontractor shall submit Material Test Reports showing actual relevant chemical, mechanical, and electrical properties of materials used and providing traceability to the actual material. Material certifications from sub-tier suppliers shall also be submitted. One copy is to be submitted upon Subcontractor acceptance for use.

**3.11.2 Inspection and Test Reports:** Copies of the original reports of all required inspections, tests and examinations, which have been properly validated by authorized personnel.

**3.11.3 Repair Documentation:** Repair documentation specified in NCSX-CSPEC-141-01-00, paragraph 3.3.2.2 .

**3.12 PPPL Receiving and Inspection:** PPPL will perform Receiving Inspection on items or services supplied by Subcontractor, using either a sampling plan or 100% inspection. Discrepant items or services will be rejected and returned to Subcontractor or reworked by PPPL at the Subcontractor's expense.

## 4. DELIVERABLES

**4.1. Weekly Reports:** Weekly status reports covering technical, administrative, and Quality activities shall be provided to Princeton's Technical and Administrative Representatives by e-mail every Friday during the period of performance.

### 4.2 Earned Value Reporting

The Contractor shall prepare and submit monthly e-mail reports indicating earned value achieved. This will be a simplified earned value reporting requirement that will require the following actions by the contractor in preparation for earned value reporting:

- The Contractor will submit a resource-loaded (fully loaded dollars only) schedule that clearly indicates the tasks to be accomplished, the time frame over which each task will be accomplished, and the resources assigned to that task. This schedule will be submitted within three (3) weeks of contract award.
- The Contractor will monthly (e-mail report satisfactory) report costs (accrued and actual) against each task on the resource-loaded schedule. The first report shall be submitted at the end of the first calendar month of the contract award (i.e., if contract awarded in January 2003, the first report will be provided at the end of January 2003).
- The Contractor shall monthly report percent complete on each task (e-mail report satisfactory). PPPL will then use this percent complete to determine the earned value based on the total resources applied to each task.
- On an exception basis, PPPL will request explanation and proposed corrective action plan on those tasks that develop significant unfavorable schedule or cost variances.

**4.3 Technical Reports:** Provide (3) printed copies and (1) electronic copy in Adobe Acrobat .pdf format of all technical reports by the dates specified in the Subcontract.

**4.4 Prototype Processing Plans:** MIT & QA Plans for the prototype Winding Form (2.6)

**4.5 Preliminary Production Processing Plans:** as described in 2.4.

**4.6 Prototype Winding Form:** Per this SOW. Packaging and shipping details shall be subject to prior PPPL approval.

**4.7 Production Processing Plans:** MIT & QA Plans and a firm fixed price and schedule proposal for the production winding forms as described in Sect. 2.8 and 2.9 of this document.

**4.8 Documentation:** As described in Sect. 3.11 of this SOW.

**4.9 Tooling:** All tooling specially fabricated for the performance of this SOW shall become the property of the United States Government. Disposition will be per direction of PPPL. In the preparation of a fixed price proposal for the production coils, Subcontractor shall assume that the tooling is not a deliverable.

**PRINCETON UNIVERSITY  
PLASMA PHYSIC LABORATORY—PPPL**

<b>PRODUCT QUALITY CERTIFICATION AND SHIPPING RELEASE</b>						
<b>PROJECT</b>	<b>ITEM DESCRIPTION</b>				<b>SHIPMENT NUMBER</b>	
<b>PPPL Subcontract / Order No.</b>	<b>REV.</b>	<b>ITEM NO.</b>	<b>SUBCONTRACTOR REFERENCE NO.</b>	<b>REV.</b>	<b>QUANTITY SHIPPED</b>	
<p><b>SUBCONTRACTOR'S CERTIFICATION</b></p> <p>This is to certify that the products and services identified herein have been produced under a controlled quality assurance program and are in conformance with the procurement requirements including applicable codes, standards and specifications as identified in the above-referenced documents unless noted below. Any supporting documentation will be retained in accordance with the procurement requirements.</p> <p><b>SIGNED:</b> _____ <b>DATE:</b> _____</p> <p><b>TITLE:</b> _____ <b>COMPANY:</b> _____</p>						
<p><b>PPPL (AUTHORIZED REPRESENTATIVE) SHIPPING RELEASE</b></p> <p>This is to certify that evidence supporting the above Subcontractor's Certification statement has been audited and no product/service nonconformances from procurement requirements have been found unless noted below. This product/service is hereby released for shipment.</p> <p>This section serves as the Quality Assurance release for the above described product for shipment. It does not constitute an acceptance thereof and does not relieve the Vendor, Manufacturer or Contractor of any and all responsibility or obligation imposed by the purchase contract. It does not waive any rights the Purchaser may have under the purchase contract, including the Purchaser's right to reject the above described material upon discovery of any deviations from requirements of the purchase contract, drawings and specifications.</p>						
<b>NONCONFORMANCES FROM PROCUREMENT QUALITY REQUIREMENTS:</b>						
<b>REMARKS/PRODUCT SERIAL NUMBERS:</b>						
<b>BY PPPL QA REPRESENTATIVE (OR DESIGNEE)</b>				<b>DATE</b>		